
वस्त्रादि — हथकरघा निर्मित सूती विरंजित,
रंजित, छापेदार, धारीदार अथवा चौखानेदार
परिधान सामग्री — विशिष्टि

(दूसरा पुनरीक्षण)

**Textiles — Handloom Cotton Dress
Material, Bleached, Dyed, Printed,
Striped or Checked — Specification**

(Second Revision)

ICS 59.080.30

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FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textiles Division Council.

This standard was originally published in 1957 and was subsequently revised in 1991. The standard has again been revised to incorporate the following major changes:

- a) Method of test for count of yarn along with its tolerance has been specified;
- b) Tolerances for ends/dm, picks/dm and mass have been modified;
- c) Test method for identification of material has been incorporated;
- d) Sampling plan has been updated;
- e) BIS certification marking clause has been modified; and
- f) References to Indian Standards have been updated.

The composition of the Committee responsible for the formulation of this standard is given in Annex E.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard***TEXTILES — HANDLOOM COTTON DRESS MATERIAL,
BLEACHED, DYED, PRINTED, STRIPED OR
CHECKED — SPECIFICATION***(Second Revision)***1 SCOPE**

1.1 This standard prescribes constructional particulars and other requirements for twenty varieties of handloom cotton dress material, bleached, dyed, printed, striped or checked.

1.2 This standard does not specify general appearance, feel, finish, etc.

2 REFERENCES

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent edition of these standards.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of the cloth to this standard. However, in all cases of disputes, the specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 YARN

The cotton yarn used shall conform to the requirements specified in IS 171.

5 REQUIREMENTS

5.1 The cloth shall be woven in plain weave.

5.2 The cloth shall conform to the requirements specified in Table 1.

5.2.1 However, the breaking load requirement shall be an optional requirement. It shall be enforced only when conformance of cotton yarn to the requirements specified in IS 171 is not known.

5.3 The cloth shall also conform to the requirements specified in Table 2.

5.4 Dimensions

The length and width of the cloth, when determined in accordance with IS 1954, shall be as agreed to between the buyer and the seller or as declared by the seller, subject to the tolerances specified in the Government of India, Ministry of Commerce and Industry (Trade and Merchandise Marks) Notification No. S.O. 2937 dated 20 September 1962 issued under the *Trade and Merchandise Marks Act*, 1958 (43 of 1958) (see Annex C).

5.5 Sealed Sample

In order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel and shade, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 INSPECTION

6.1 The cloth when visually inspected should be free from the major flaws listed in Annex D.

6.1.1 The number of permissible major flaws per unit length shall be as agreed to between the buyer and the seller.

7 SAMPLING**7.1 Lot**

The quantity of the cloth of the same variety delivered to one buyer against one dispatch note shall constitute a lot.

7.2 The conformity of a lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from it.

7.3 Unless otherwise agreed, the number of pieces to be selected at random for inspection shall be in accordance with Table 3. For random selection of samples, IS 4905 may be followed.

**Table 1 Constructional Particulars and Breaking Load Requirements for Handloom Cotton Dress
Material, Bleached, Dyed, Printed, Striped or Checked**

(Clause 5.2)

Sl No.	Variety No.	Count of Yarn (for Guidance only) Universal Count (Cotton Count)		Ends/dm	Picks/dm	Mass g/m ²	Breaking Load N	
		Warp	Weft				Warp	Weft
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
i)	1	30 tex (20s)	30 tex (20s)	190	170	112	220	200
ii)	2	30 tex (20s)	30 tex (20s)	168	152	100	200	180
iii)	3	23 tex (26s)	23 tex (26s)	290	275	132	240	240
iv)	4	23 tex (26s)	23 tex (26s)	220	200	100	180	170
v)	5	20 tex (30s)	20 tex (30s)	380	240	126	260	180
vi)	6	20 tex (30s)	20 tex (30s)	295	230	110	200	160
vii)	7	20 tex (30s)	20 tex (30s)	240	220	95	180	160
viii)	8	20 tex (30s)	20 tex (30s)	190	170	75	150	130
ix)	9	20 tex (30s)	20 tex (30s)	100	100	42	100	100
x)	10	16 tex (36s)	16 tex (36s)	240	220	75	160	140
xi)	11	16 tex (36s)	16 tex (36s)	100	100	35	80	80
xii)	12	15 tex (40s)	15 tex (40s)	440	250	105	320	180
xiii)	13	15 tex (40s)	15 tex (40s)	280	270	84	200	200
xiv)	14	15 tex (40s)	15 tex (40s)	220	200	64	160	160
xv)	15	10 tex (60s)	10 tex (60s)	380	380	78	250	250
xvi)	16	10 tex (60s)	10 tex (60s)	295	285	60	200	190
xvii)	17	10 tex (60s)	10 tex (60s)	280	250	55	190	160
xviii)	18	7.5 tex (80s)	7.5 tex (80s)	320	300	48	170	160
xix)	19	7.5 tex (80s)	7.5 tex (80s)	290	255	42	150	125
xx)	20	6 tex (100s)	6 tex (100s)	335	305	41	140	120
Tolerance, percent	—	± 5	± 5	± 5	± 5	± 5	- 5 on average value and - 15 on individual reading	
Method of Test, Ref to	—	IS 3442		IS 1963		IS 1964 or Annex B	IS 1969 (Part 1)	

**Table 2 Other Requirements for Handloom Cotton Dress Material, Bleached,
Dyed, Printed, Striped or Checked**

(Clause 5.3)

Sl No.	Characteristic	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional change percent, <i>Max</i>	4	IS 2977
ii)	Scouring loss percent, <i>Max</i>	2.5	IS 1383
iii)	Fibre identification	100 percent cotton	IS 667
iv)	pH value of the aqueous extract	6.0 to 8.5	IS 1390
v)	Colour fastness (for dyed fabrics only): a) Light b) Washing Test(3): 1) Change in colour 2) Staining on fabric c) Bleaching: 1) Change in colour 2) Staining on fabric d) Perspiration: 1) Change in colour 2) Staining on fabric	4 or better 4 or better 4 or better	IS/ISO 105-B01 or IS/ISO 105-B02 IS/ISO 105-C10 IS/ISO 105-N01 IS/ISO 105-E04

Table 3 Sample Size and Permissible Number of Non-conforming Pieces*(Clause 7.3)*

Sl No.	Lot Size	Sample Size	Permissible Number of Non-conforming Pieces	Sub-sample Size
(1)	(2)	(3)	(4)	(5)
i)	Up to 90	5	0	3
ii)	91 to 150	8	0	3
iii)	151 to 500	13	1	5
iv)	501 to 1 200	20	1	5
v)	1 201 to 10 000	32	2	8
vi)	10 001 to 35 000	50	3	8
vii)	35 001 to 500 000	80	5	13
viii)	500 001 and above	125	7	13

7.4 Number of Samples and Criteria for Conformity

The number of samples to be drawn and the criteria for conformity of the material for various characteristics shall be as follows:

Sl No.	Characteristics	Number of Samples	Criteria for Conformity
(1)	(2)	(3)	(4)
i)	Ends, picks, mass, length, width and visual inspection	According to col (2) of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col (3) of Table 3
ii)	Dimensional change, scouring loss, fibre identification, pH value, colour fastness and breaking load	According to col (4) of Table 3	All the test pieces shall meet the requirement

8 MARKING

8.1 The cloth shall be suitably marked with the following information:

- Name of the material and variety number;
- Length (m) and width (cm);
- GSM (g/m²);
- Indication of the source of manufacture; and
- Other declarations as per law in force.

8.2 BIS Certification Marking

The product(s) conforming to the requirements of

this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.

9 PACKING

Unless otherwise agreed upon by the buyer and seller the cloth shall be packed in bales or cases in accordance with the procedure laid down in IS 1347 or IS 293.

ANNEX A

(Clause 2)

LIST OF REFERRED STANDARDS

IS No.	Title	IS No.	Title
IS 171 : 1993	Textiles — Ring spun grey cotton yarn for weaving — Specification (<i>fourth revision</i>)		force using the strip method (<i>fourth revision</i>)
IS 293 : 1980	Code of seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	IS 2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<i>first revision</i>)
IS 667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	IS 3442 : 2023	Textiles — Method for determination of crimp and linear density of yarn removed from fabric (<i>second revision</i>)
IS 1347 : 1972	Specification for inland packaging of cotton cloth and yarn (<i>first revision</i>)	IS 4905 : 2015/ ISO 24153 : 2009	Random sampling and randomization procedures (<i>first revision</i>)
IS 1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>first revision</i>)	IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight
IS 1390 : 2022/ ISO 3071 : 2020	Textiles — Determination of pH of aqueous extract (<i>third revision</i>)	IS/ISO 105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test
IS 1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	IS/ISO 105-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)	IS/ISO 105-E04 : 2013	Textiles — Tests for colour fastness: Part E04 Colour fastness to perspiration (<i>first revision</i>)
IS 1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)	IS/ISO 105-N01 : 1993	Textiles — Tests for colour fastness: Part N01 Colour fastness to bleaching: Hypochlorite
IS 1969 (Part 1) : 2018/ISO 13934 - 1 : 2013	Textiles — Tensile properties of fabrics: Part 1 Determination of maximum force and elongation at maximum		

ANNEX B

(Table 1)

METHOD FOR DETERMINATION OF MASS OF FABRIC

B-1 Cut four specimens of 100 mm × 100 mm each from a sample. Condition all the specimens in a desiccator charged with saturated solution of sodium nitrate at 27 °C ± 2 °C for a period of 24 hours. Remove all the specimens from the desiccator and

immediately determine their collective mass in a weighing balance to the nearest milligram.

B-2 Calculate the mass of the fabric in g/m².

ANNEX C

(Clause 5.4)

**EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE AND
INDUSTRY (TRADE AND MERCHANDISE MARKS) NOTIFICATION NO. S.O.2937
DATED 20 SEPTEMBER 1962**

C-1 A trade description of length stamped on grey, bleached, mercerized or coloured cotton piece goods:

- a) In pieces stamped as of length 9 meters and below, the stamped length shall not exceed the actual length by more than 1 percent of the piece length or 7.5 cm, whichever is less; and
- b) In pieces stamped as of length above 9 metres, the stamped length shall not exceed the actual length by more than 0.6 percent of the piece length or 7.5 cm, whichever is higher.

Provided that the average length of the pieces in question shall not be less than the stamped length.

C-2 A trade description of width stamped on grey, bleached, mercerized or coloured cotton piece goods:

- a) In pieces stamped as of width 102 cm or below, the stamped width shall not exceed the actual width at any point by more than 1.3 cm;
- b) In pieces stamped as of width over 102 cm up to 152 cm, the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece; and
- c) In pieces stamped as of width 152 cm and above, the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece or 2.5 cm, whichever is less.

ANNEX D*(Clause 6.1)***LIST OF MAJOR FLAWS**

- a) One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double end running throughout the piece;
- b) Undressed Snarls noticeable over a length exceeding 5 percent of the length of the piece;
- c) Smash definitely rupturing the texture of the fabric;
- d) Hole, cut or tear;
- e) Reed marks prominently noticeable over a length exceeding 5 percent of the length of the piece;
- f) Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece;
- g) Skewing of more than three percent on weft;
- h) Weft crack or two or more missing picks across the width of the fabric;
- j) Warp or weft bar due to the difference in raw material, count, twist, lustre, colour, shade or spacing of adjacent groups of yarns (starting mark);
- k) More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm;
- m) Noticeable warp or weft float in the body of the fabric;
- n) Noticeable oil or other stain in the fabric;
- p) Oily weft in the fabric;
- q) Prominently noticeable slub;
- r) Conspicuous broken pattern;
- s) Gout due to foreign matter, usually lint or waste woven into the fabric;
- t) Prominent selvedge defect;
- u) Significant shading or listing in fabrics having a gradual change in tone or depth of shade of fabric (excluding selvedge or border running parallel to the selvedge);
- v) Coloured flecks;
- w) Blurred or dark patch;
- y) Patchy, streaky or uneven dyeing;
- z) Dye bar; and
- aa) Fuzzy appearance.

ANNEX E

(Foreword)

COMMITTEE COMPOSITION

Handloom and Khadi Sectional Committee, TXD 08

<i>Organization</i>	<i>Representative(s)</i>
Weavers Service Centre, Delhi	SHRI VISHESH NAUTIYAL (Chairperson) SHRI VIKAS KUMAR (<i>Alternate</i>)
Baster Adimjati Sewak Sangh, Baster	SHRI SUMIT DAS SHRI AMIT DAS (<i>Alternate</i>)
Central Pollution Control Board, New Delhi	SHRI P. K. MISHRA SHRI RISHABH SRIVASTAV (<i>Alternate</i>)
Central Reserve Police Force, New Delhi	SHRI D. P. UPADHYAY SHRI SANJEEV KUMAR SINGH (<i>Alternate</i>)
Department of Handlooms & Textiles, Chennai	SHRI T. P. RAJESH DR K. KARNAN (<i>Alternate</i>)
Gandhigram Rural Institute, Dindigul	REPRESENTATIVE
Haryana Khadi Gramodyog Sangh, Karnal	SHRI PAWAN GARG SHRI R. S. YADAV (<i>Alternate</i>)
ICAR – Central Institute for Research on Cotton Technology, Mumbai	DR SUJATA SAXENA DR A. S. M. RAJA (<i>Alternate</i>)
Indian Institute of Handloom Technology, Varanasi	DR P. THENNARASU
Indian Institute of Handloom Technology, Jodhpur	DR J. SIVAGNANAM
Indo Tibetan Border Police, New Delhi	SHRI UTTAM KUMAR SHRI ANAND KUMAR (<i>Alternate</i>)
Jan Sewa Ashram, Aligarh	SHRI R. K. SHARMA SHRI AKHILESH KUMAR AWASTHI (<i>Alternate</i>)
Karnatka Khadi Gramodyog Samyuktha Sangha, Hubli	SHRI K. V. PATTAR SHRI SHIVANANDA S. (<i>Alternate</i>)
Khadi & Village Industries Commission, New Delhi	SHRI P. NALLAMUTHU SHRI RAM NARAYAN (<i>Alternate</i>)
Khadi Dyers & Printers, Mumbai	SHRI D. N. BHATT SHRI V. D. JOSHI (<i>Alternate</i>)
Khadi Gramodyog Mandal, Rampur	SHRI RAKESH CHAUDHARY SHRI PRINCE CHAUDHARY (<i>Alternate</i>)
Kshetriya Khadi Gramodyog Samiti, Dausa	SHRI R. K. SINGH
Madhya Bharat Khadi Sangh, Gwalior	SHRIMATI NEELU MEKLE SHRI HARISH MEKLE (<i>Alternate</i>)
Mahatma Gandhi Institute for Rural Industrialization, Wardha	REPRESENTATIVE

<i>Organization</i>	<i>Representative(s)</i>
Metpalli Khadi Gramodyog Pratisthan, Metpalli	SHRI G. MADHAV
Ministries of Defence (DGQA), New Delhi	SHRI ARVIND COMPATHANE SHRI N. SENTHIL KUMAR (<i>Alternate</i>)
Ministries of Health, New Delhi	REPRESENTATIVE
National Handloom Development Corporation Ltd, Gautam Budh Nagar	DR SAKTHIVEL PERUMALSAMY SHRI JITENDRA TOLAMBIYA (<i>Alternate</i>)
Northern Railways, New Delhi	SHRI SUDHANSHU KUMAR GUPTA
Northern India Textile Research Association, Ghaziabad	DR M. S. PARMAR SHRI SANJEEV SHUKLA (<i>Alternate</i>)
Office of The Development Commissioner for Handlooms, New Delhi	SHRI SIDDHARTH SINGH SHRI VINAY KUMAR (<i>Alternate</i>)
Rastriya Khadi Gramodyog Federation, Moradabad	SHRI ANIL KUMAR SINGH SHRI KULDEEP SINGH (<i>Alternate</i>)
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Swastik Gramodyog Samiti, Delhi	SHRI M. L. PATHAK SHRI ABHISHEK DIXIT (<i>Alternate</i>)
Textiles Committee, New Delhi	SHRI KARTIKAY DHANDA SHRIMATI SHILPI CHAUHAN (<i>Alternate</i>)
The Cotton Textiles Export Promotion Council (TEXPROCIL), Mumbai	DR SIDDHARTHA RAJAGOPAL SHRI RAJESH SATAM (<i>Alternate</i>)
The Handloom Export Promotion Council, Chennai	DR M. SUNDAR EXPORT PROMOTION OFFICER (<i>Alternate</i>)
The Tamil Nadu Handloom Weavers' Cooperative Society Ltd, Chennai	SHRI T. N. VENKATESH SHRI K. KATHIRESAN (<i>Alternate</i>)
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Member Secretary
SHRI SWAPNIL
SCIENTIST 'B'/ASSISTANT DIRECTOR
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This Indian Standard has been developed from Doc No.: TXD 08 (20808).

Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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